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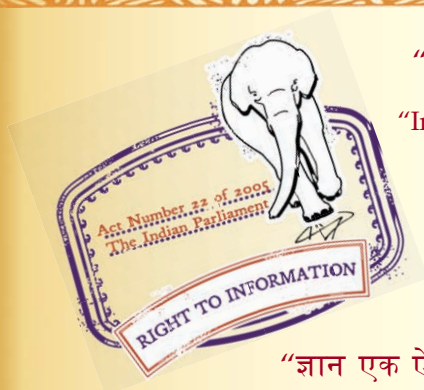
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IS 6336 (1989): Screws for thrust pads (fixtures) [PGD 2: Machine Tool Elements and Holding Devices]



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“Knowledge is such a treasure which cannot be stolen”



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*Indian Standard*  
**SCREWS FOR THRUST PADS ( FIXTURES ) —  
SPECIFICATION**  
*( First Revision )*

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**BUREAU OF INDIAN STANDARDS**  
MANAK BHAVAN, 9 BAHADUR SHAH ZAFAR MARG  
NEW DELHI 110002

October 1989

Price Group 1

## FOREWORD

This Indian Standard ( First Revision ) was adopted by the Bureau of Indian Standards on 13 March 1989, after the draft finalized by the Machine Tools, Machine Tool Elements and Woodworking Machines Sectional Committee had been approved by the Mechanical Engineering Division Council.

This standard was first published in 1971. The committee responsible for the formulation of this standard decided to revise the same to bring it in line with the standards on thrust pads and clamping screws which are also being revised.

In this revision, Type A has been incorporated to suit thrust-pad with snap ring which is according to DIN 6332-1981 'Grub screws with thrust point', issued by the Deutsches Institut für Normung ( DIN ).

# Indian Standard

## SCREWS FOR THRUST PADS ( FIXTURES ) SPECIFICATION ( First Revision )

### 1 SCOPE

This standard specifies the dimensions and other requirements for screws for thrust pads used in the assembly of clamping screws according to IS 6338 : 1988 'Specification for clamping screws (first revision)'.

### 2 REFERENCES

| IS No.                     | Title   |
|----------------------------|---|
| IS 1367<br>(Part 2) : 1979 | Technical supply conditions for threaded fasteners: Part 2 Product grade and tolerances (second revision)   |
| IS 1367<br>(Part 3) : 1979 | Technical supply conditions for threaded fasteners: Part 3 Mechanical properties and test method for bolts, screws and studs, with full loadability (second revision) |
| IS 2102<br>(Part 1) : 1980 | General tolerances for dimensions and form and position: Part 1 General tolerances for linear and angular dimensions (second revision)                                |
| IS 6338 : 1988             | Specification for clamping screws (first revision)  |

### 3 TYPES

**3.1 Type A** — screw for thrust pad using snap ring.

**3.2 Type B** — screw for thrust pad using cylindrical pin.

### 4 DIMENSIONS

#### 4.1 Dimensions of Screws for Thrust Pads

The dimensions of screws for thrust pads shall be as given in Table 1.

#### 4.2 Grade

The grade of the screw shall be of product Grade A according to IS 1367 (Part 2) : 1979.

### 5 MATERIAL

#### 5.1 Mechanical Properties

The screws for thrust pads shall be manufactured from steel conforming to property class 5.8 as specified in IS 1367 (Part 3) : 1979.

### 6 HARDNESS

The hardness of thrust surface shall be  $600 \pm 50$  HV.

### 7 FINISH

The screws shall be free from cracks, burrs, pits and other defects.

### 8 DESIGNATION

A screw for thrust-pad, Type A, having  $d_1 = M10$  and  $l = 60$  mm shall be designated as:

Screw for Thrust-Pad, AM10  $\times$  60 IS 6336

### 9 PRESERVATION AND PACKING

**9.1** Unless the purchaser has specified specific treatment at the time of making enquiry or at the time of placing order, the screws for thrust-pads shall be supplied in well cleaned condition and suitably protected against corrosion.

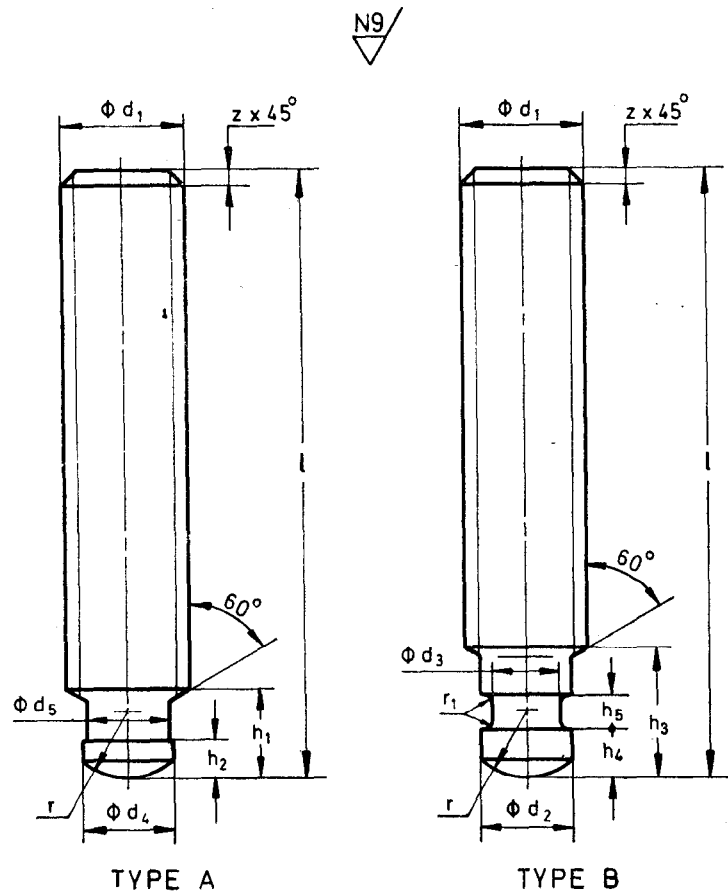
**9.2** The screws for thrust-pads shall be wrapped with moisture-proof paper and shall be packed in accordance with best trade practice.

### 10 MARKING

The screws for thrust-pads shall be marked at an appropriate place with designation and name of the manufacturer or trade-mark.

Table 1   Dimensions for Screws for Thrust Pads ( Fixtures )  
( Clause 4.1 )

All dimensions in millimetres.



| $d_1$ | $d_3$<br>$h_{11}$ | $d_3$ | $d_1$<br>$h_{11}$ | $d_3$<br>$0$<br>$-0.1$ | $r$ | $r_1$ | $h_1$ | $h_2$ | $h_3$ | $h_4$ | $h_5$ | $l$           | $z$  |
|-------|-------------------|-------|-------------------|------------------------|-----|-------|-------|-------|-------|-------|-------|---------------|------|
| M6    | 4.5               | 3     | 4.5               | 4.0                    | 3   | 0.6   | 6.0   | 2.5   | 6.5   | 2.2   | 2.2   | 30, 50        | 1.0  |
| M8    | 6                 | 4     | 6.0               | 5.4                    | 5   | 0.8   | 7.5   | 3.0   | 8.5   | 2.8   | 3     | 40, 60        | 1.25 |
| M10   | 7                 | 5     | 8.0               | 7.2                    | 6   | 0.8   | 9.0   | 4.5   | 10    | 3.2   | 3     | 60, 80        | 1.5  |
| M12   | 9                 | 6     | 8.0               | 7.2                    | 6   | 1.0   | 10.0  | 4.5   | 13    | 4.3   | 4.5   | 60, 80, 100   | 1.75 |
| M16   | 12                | 9     | 12.0              | 11.0                   | 9   | 1.0   | 12.0  | 5.0   | 17    | 6.3   | 4.5   | 80, 100, 125  | 2.0  |
| M20   | 15                | 10    | 15.5              | 14.4                   | 13  | 1.5   | 14.0  | 5.5   | 21    | 7.4   | 6     | 100, 125, 150 | 2.5  |

NOTE — Dimensional deviations for untoleranced dimensions shall be medium class according to IS 2102 ( Part 1 ) : 1980.

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**BUREAU OF INDIAN STANDARDS**

**Headquarters:**

Manak Bhavan, 9 Bahadur Shah Zafar Marg, New Delhi 110002  
Telephones : 331 01 31, 331 13 75

Telegrams : Manaksanstha  
( Common to all Offices )

**Regional Offices:**

Telephone

|   |                          |
|---|--------------------------|
| Central : Manak Bhavan, 9 Bahadur Shah Zafar Marg<br>NEW DELHI 110002 | { 331 01 31<br>331 13 75 |
|---|--------------------------|

|   |          |
|---|----------|
| Eastern : 1/14 C. I. T. Scheme VII M, V. I. P. Road, Maniktola<br>CALCUTTA 700054 | 36 24 99 |
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